

Work Order ID 74470

Monday, October 03, 2011 9:22:15 AM



Page 1

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: H.L.J

Date: 11/10/03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2661

Rev D

100



HAAS CNC VERTICAL MACHINING #1

0.00

only B.A. 11/10/13

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Fixturing Inspection last completed
11/10/12 by *only* ☐ 1-Machine Step No 1 of Folio and visually inspect as
per attached Dimension Sheet ☐ 2-Machine Step No 2 of Folio and visually
inspect as per attached Dimension

10

1

PTO7

110



CONVENTIONAL MILLING MACHINE

0.00

only B.A. 11/10/13

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

10

φ

120



QC2- Inspect parts off machine FAI/FAIB

0.00

only B.A. 11/10/13

QC

Memo

0.00

Quality Control

10

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ661-1 PAR #: N/A Fault Category: Mechanical NCR: Yes No DQA: 1 Date: 11-10-28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 11/10/31

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/12	100	1" ball nose touch the crosshatch island and make a mark .080" by .175" MACHINE. R.C. programming error	W 11-10-14	Scrap and destroy Qty 1 - Program has been fixed and updated B 73769	and 11/10/13	SK 11-10-17	W 11-10-17	S 11/10/17
		debug/modify program Prod/Eng - WOA						

NOTE: Date & initial all entries

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Page 2

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Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M117745

3250F

9:00

9:30

10X Ø M-11/10/17

10X Ø M-11/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74470

Page 3

Monday, October 03, 2011 9:22:15 AM

Item ID: D2661-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/30/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10
COUNT

11/10/18

170

Identify as per dwg & Stock Location: ST 476

0.00



Packaging

Memo

0.00

Packaging

10W SP 11-10-18

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/18

11-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 9:22:22 AM

Page 1

Work Order ID: 74470

Parent Item: D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206



Start Date: 9/30/2011

Required Date: 10/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003 		Manufactured	No			100	Each	73.0000	1	10		11/10/13	
---------------	--	--------------	----	--	--	-----	------	---------	---	----	--	----------	--

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	8	
72226	8	
MAT44	65	
72226	5	
✓ 73769	60	

+ 1 (replace scrap part)
(same batch)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74470
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.110	.109	.112	.110		
B	0.100	0.140		0.114	.113	.113	.113		
1.125-1.145 C	1.250	1.270		1.136	1.135	1.135	1.135		
D	0.615	0.685		0.675	.675	.675	.675		
E	0.240	0.260		0.250	.249	.257	.257		
1.313-1.343 F	1.437	1.467		1.322	1.322	1.322	1.322		
G	0.210	0.230		0.222	.223	.223	.222		
H	0.100	0.180		0.135	.135	.130	.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.5758	1.5742	1.576	1.575		
K	0.235	0.240		0.238	0.238	.238	.238		
L	0.100	0.120		0.111	0.111	.111	.111		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.517	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.798	.797	.796	.792		
W	0.540	0.560		0.550	.550	.550	.547		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.921	.918	.921	.920		
AA	0.490	0.510		0.500	.500	.500	.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>h.a</u> / <u>smk</u>	Audited by: <u>SL</u>
Date: <u>11/10/13</u> / <u>11/10/13</u>	Date: <u>11-10-17</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 74470
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				Date
				5	6	7	8	
A	0.100	0.140		.111	.112	.110	.110	
B	0.100	0.140		.111	.112	.111	.111	
C	1.250	1.270		1.835	1.134	1.135	1.134	
D	0.615	0.685		.675	.675	.675	.675	
E	0.240	0.260		.250	.250	.250	.250	
F	1.437	1.467		1.321	1.321	1.321	1.320	
G	0.210	0.230		.221	.220	.220	.221	
H	0.100	0.180		.135	.135	.135	.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	
J	1.565	1.585		1.574	1.574	1.574	1.574	
K	0.235	0.240		.238	.238	.238	.238	
L	0.100	0.120		.111	.111	.111	.111	
M	0.990	1.010		.997	.997	.997	1.000	
N	0.510	0.515		.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.313	0.318		.315	.315	.315	.315	
S	0.315	0.322		.317	.317	.317	.317	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		.798	.798	.797	.798	
W	0.540	0.560		.547	.547	.546	.547	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.257	0.262		.258	.258	.258	.258	
Z	0.912	0.932		.916	.918	.918	.918	
AA	0.490	0.510		.500	.500	.500	.500	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								
AF								
Accept/Reject								

Measured by: <i>cmf</i>
Date: 11/16/13

Audited by: <i>Y</i>
Date: 12-17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 746780
Description: 206 Saddle, Outboard, Right side		Part Number: D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

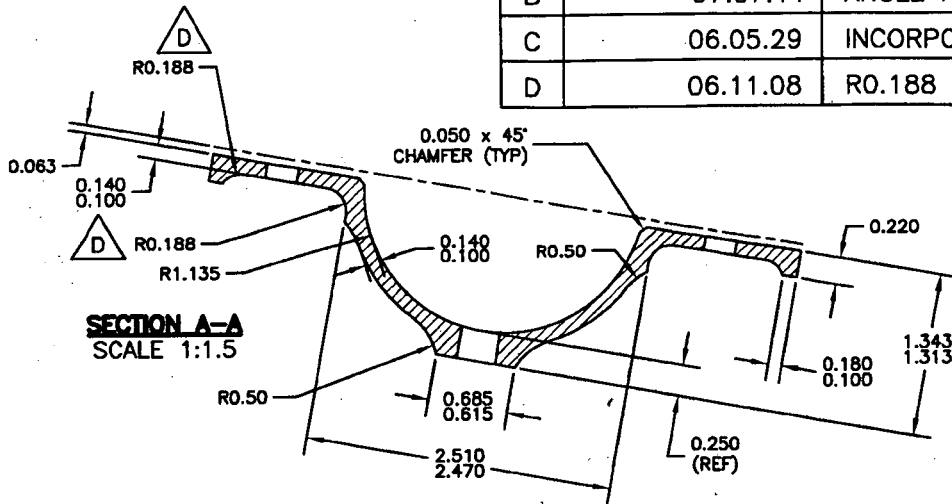
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions		Date
				9	10	
A	0.100	0.140		.111	.111	
B	0.100	0.140		.111	.111	
C	1.250	1.270		1.135	1.134	
D	0.615	0.685		.675	.675	
E	0.240	0.260		.251	.251	
F	4.437	4.467		1.321	1.320	
G	0.210	0.230		.221	.221	
H	0.100	0.180		.135	.135	
I	2.470	2.510		2.490	2.490	
J	1.565	1.585		1.573	1.573	
K	0.235	0.240		0.238	0.238	
L	0.100	0.120		0.111	0.111	
M	0.990	1.010		0.999	0.999	
N	0.510	0.515		0.512	0.512	
O	5.990	6.010		6.000	6.000	
P	1.245	1.255		1.250	1.250	
Q	2.495	2.505		2.500	2.500	
R	0.313	0.318		0.315	0.315	
S	0.315	0.322		.317	.317	
T	2.495	2.505		2.500	2.500	
U	1.357	1.367		1.362	1.362	
V	0.787	0.807		.797	.795	
W	0.540	0.560		.547	.548	
X	1.674	1.684		1.679	1.679	
Y	0.257	0.262		.258	.258	
Z	0.912	0.932		.918	.920	
AA	0.490	0.510		.498	.500	
AB	0.178	0.198		.188	.188	
AC						
AD						
AE						
AF						
Accept/Reject						

Measured by: <u>AMR</u>	Audited by: <u>JL</u>
Date: <u>11/10/13</u>	Date: <u>11-10-17</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN	<i>PH</i>	DRAWN BY	CB	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D2661
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE OUTSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313		



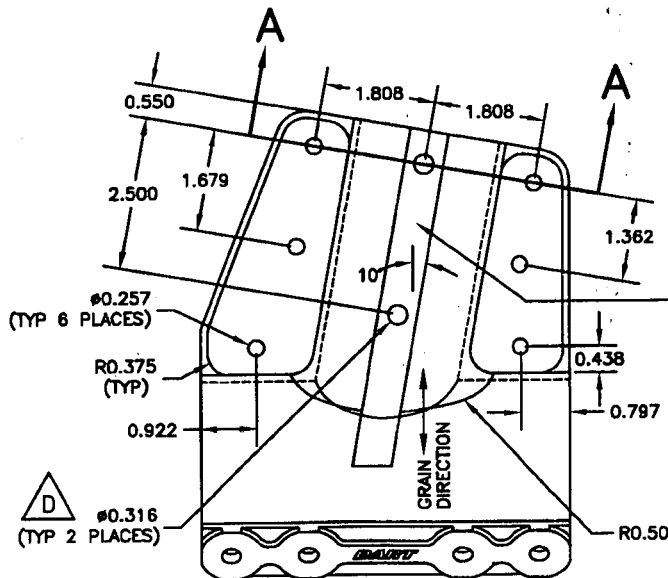
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07.02.12

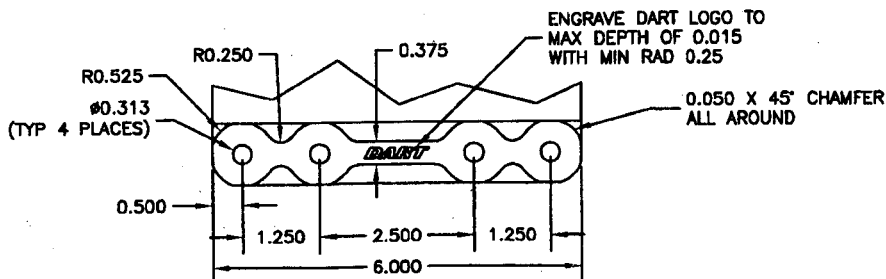
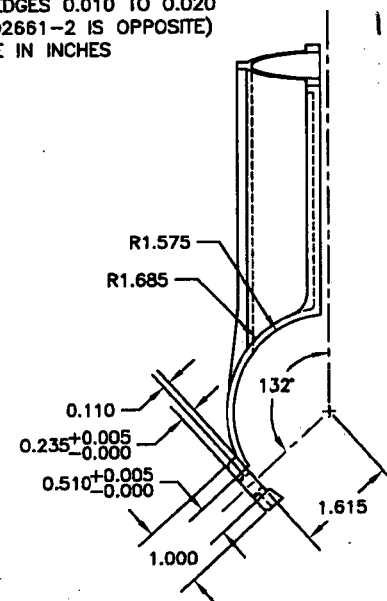
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries